

Environmental Technology Verification Report

Paint Overspray Arrestor Farr Company Riga-Flo 200

Prepared by



Research Triangle Institute

Under a Cooperative Agreement with



U.S. Environmental Protection Agency

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Environmental Technology Verification Report

Paint Overspray Arrestor

**Farr Company
Riga-Flo 200**

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Notice

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Availability of Verification Statement and Report

Copies of the public Verification Statement and Verification Report are available from the following:

1. **Research Triangle Institute**

P.O. Box 12194
Research Triangle Park, NC 27709-2194

Web site: <http://etv.rti.org/apct/index.html>
or <http://www.epa.gov/etv> (*click on partners*)

2. **USEPA / APPCD**

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Web site: <http://www.epa.gov/etv/library.htm> (*electronic copy*)
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Abstract

Paint overspray arrestors (POAs) were evaluated by the Air Pollution Control Technology (APCT) pilot of the Environmental Technology Verification (ETV) Program. The performance factor verified was the particle filtration efficiency as a function of size for particles smaller than 10 µm. The APCT ETV Program developed a generic verification protocol for testing filtration efficiency that is based on EPA Method 319. The protocol was developed by RTI, reviewed by a technical panel of experts, and approved by EPA. The protocol addresses several issues that Method 319 does not cover, including periodic testing, acquisition of POAs for testing, and product definition. A Test/Quality Assurance Plan was prepared which addresses the test procedure and quality assurance and quality control requirements for obtaining verification data of sufficient quantity and quality to satisfy the data quality objectives.

RTI performed tests on Farr's Riga-Flo 200 during the period October 5-8, 1999. Filter efficiencies were determined. For ready comparison, the filtration efficiency requirements of the National Emission Standards for Hazardous Air Pollutants (NESHAP) are tabulated with the test results. The results indicate that the Riga-Flo 200 met the NESHAP requirements for new and existing sources.

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List of Abbreviations and Acronyms

APCT	Air Pollution Control Technology
APPCD	Air Pollution Prevention and Control Division
ASME	American Society of Mechanical Engineers
cfm	cubic feet per minute
cm	centimeter
Diam.	Diameter
DQO	data quality objective
EPA	U.S. Environmental Protection Agency
ETV	Environmental Technology Verification
fpm	feet per minute
ft ³	cubic foot
g	gram
Geo.	geometric
HEPA	high efficiency particulate air
ID	inside diameter
in.	inch
kW	kilowatt
L	liter
mL	milliliter
mm	millimeter
m/s	meters per second
NESHAP	National Emission Standards for Hazardous Air Pollutants
OPC	optical particle counter
Pa	pascal
POA	paint overspray arrestor
PSL	polystyrene latex
QA	quality assurance
RTI	Research Triangle Institute
s or sec	second
µm or um	micrometer

Acknowledgments

RTI acknowledges the support of all those who helped plan and conduct the verification activities. In particular, we would like to thank Ted Brna, EPA Project Manager, and Paul Groff, EPA Quality Manager, of EPA's National Risk Management Research Laboratory in Research Triangle Park, NC. Finally we would like to acknowledge the assistance and participation of Don Thornburg of Farr.

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SECTION 1 INTRODUCTION

The U.S. Environmental Protection Agency (EPA) has created the Environmental Technology Verification (ETV) Program to facilitate the deployment of innovative or improved technologies through performance verification and information dissemination. The ETV Program is intended to assist and inform those involved in the design, distribution, permitting, and purchase of environmental technologies.

The U.S. EPA's partner in the Air Pollution Control Technology (APCT) Program is Research Triangle Institute (RTI). The APCT Program, with the full participation of the technology developer, develops plans, conducts tests, collects and analyzes data, and reports findings. The evaluations are conducted according to a rigorous protocol and quality assurance and quality control oversight. The APCT Program verifies the performance of commercial-ready technologies used to control air pollutant emissions, with an emphasis on technologies for controlling particulate matter, volatile organic compounds, nitrogen oxides, and hazardous air pollutants. The Program develops standardized verification protocols and test plans, conducts independent testing of technologies, and prepares verification test reports and statements for broad dissemination.

SECTION 2 VERIFICATION TEST DESCRIPTION

The paint overspray arrestor was tested in accordance with the APCT "Generic Verification Protocol for Paint Overspray Arrestors"¹ and the "Test/QA Plan for Paint Overspray Arrestors."² This protocol incorporates all requirements of EPA Method 319: Determination of Filtration Efficiency for Paint Overspray Arrestors. Method 319³ is part of the National Emission Standards for Hazardous Air Pollutants (NESHAP) for Aerospace Manufacturing and Rework Facilities.⁴ The protocol also includes requirements for quality management, quality assurance, procedures for product selection, auditing of the test laboratories, and reporting format.

Filtration efficiency was computed from aerosol concentrations measured upstream and downstream of an arrestor installed in a laboratory test rig. The aerosol concentrations upstream and downstream of the arrestors were measured with an aerosol analyzer that simultaneously counts and sizes the particles in the aerosol stream. The aerosol analyzer covered the particle diameter size range from 0.3 to 10 µm in a series of contiguous sizing channels. Each sizing channel covered a narrow range of particle diameters. For example, channel 1 covered from 0.3 to 0.4 µm, channel 2 from 0.4 to 0.5 µm, and channel 15 from 7 to 10 µm. By taking the ratio of the downstream to upstream particle counts for each channel, the filtration efficiency was computed for each of the sizing channels.

The upstream and downstream aerosol measurements were made while a test aerosol was injected into the air stream upstream of the arrestor [ambient aerosol is first removed from the upstream air with high efficiency particulate air (HEPA) filters on the inlet of the test rig]. This test aerosol spanned the particle

Farr Riga-Flo 200

size range from 0.3 to 10 μm and provided a sufficient upstream concentration in each of the sizing channels to allow calculation of filtration efficiencies up to 99%.

The following series of tests were performed at a face velocity of 120 fpm (0.61 m/s):

- Three arrestors were tested using a liquid-phase aerosol challenge,
- Three arrestors were tested using a solid-phase aerosol challenge,
- “No-filter” control tests (one performed prior to each arrestor test),
- One HEPA filter control test, and
- One reference filter control test.

The test series is exhibited in Table 5. Additional details on the test procedure are provided in Appendix A.

TABLE 5. TEST SERIES

RTI Test No.	TYPE OF TEST				Challenge Aerosol
	No-Filter	Test Arrestor	HEPA Filter	Reference Filter	
10059901	X				Solid-Phase
10059903				X	
10059904	X				
10059905		X			
10059906	X				
10069901		X			
10069902	X				
10069903		X			
10059902			X		
10089904	X				Liquid-Phase
10089905		X			
10089906	X				
10089907		X			
10089908	X				
10089909		X			

2.1 SELECTION OF PAINT OVERSPRAY ARRESTORS FOR TESTING

The test arrestors (Riga-Flo 200) were supplied to the test laboratory directly from the manufacturer's stock or normal production line with a letter from Don Thornburg, Engineering Manager, attesting that the arrestors comply fully with their Bill of Materials. The manufacturer supplied the test laboratory with 12 arrestors; the test laboratory randomly selected six for testing.

SECTION 3 DESCRIPTION OF ARRESTOR

As shown in Figure 1 (page iii), the Farr Riga-Flo 200 is a rigid cell arrestor with nominal dimensions of 24 x 24 x 12 in. (0.61 x 0.61 x 0.30 m). The arrestor has a metal frame, and the filter media color is yellow. The label is white with green printing and is about 5 x 8 in. (0.13 x 0.20 m) in size. The label includes the following information: Farr Riga-Flo-200, 24 x 24 x 12, Part No. 09026003. There is an arrow indicating flow direction.

SECTION 4 VERIFICATION OF PERFORMANCE

4.1 QUALITY ASSURANCE

The verification tests were conducted in accordance with an approved Test/Quality Assurance (QA) Plan.² The EPA Quality Manager conducted an independent assessment of the test laboratory in August 1999 and found that the test laboratory was being operated as specified in the Test/QA Plan. Additionally, APCT Quality Assurance staff have reviewed the results of this test and have found that the results meet data quality objectives in the Test/QA Plan. Certificates of Calibration for the optical particle counter and the airflow reference devices are provided in Appendix B.

4.2 RESULTS

Tables 6 and 7, and Figures 2 through 5, summarize the fractional filtration efficiency measurements for the solid- and liquid-phase tests. Upstream and downstream particle count data for each test are provided in Appendix C.

The initial (new condition) pressure drop across each test arrestor at the 120 fpm (0.61 m/s) test velocity [for a flowrate of 480 cfm (0.23 m³/s)] is shown in Table 8. The pressure drop across the tested arrestors ranged from 0.14 to 0.25 in. H₂O (35 to 62 Pa) for each of the six arrestors tested.

Tables 1-4 (page iv) present the filtration efficiency requirements of the Aerospace NESHPAP and the corresponding efficiencies measured for the tested arrestor system. The test results indicate that the tested arrestor met the NESHPAP requirements for new and existing sources.

4.3 LIMITATIONS AND APPLICATIONS

This verification report addresses two aspects of paint overspray arrestor performance: filtration efficiency and pressure drop. Users of this technology may wish to consider other performance parameters such as service life and cost when selecting a paint overspray arrestor for their use.

In accordance with the generic verification protocol, this Verification Statement is applicable to paint overspray arrestors manufactured between the publication date of the Verification Statement and 12 months thereafter.

As stated in Section 1.3 of Method 319³, "for a paint arrestor system or subsystem which has been tested by this method, adding additional filtration devices to the system or subsystem shall be assumed to result in an efficiency of at least that of the original system without additional testing."

SECTION 5 REFERENCES

1. Generic Verification Protocol for Paint Overspray Arrestors, Research Triangle Institute, Research Triangle Park, NC, August 1999.
2. Test/QA Plan for Paint Overspray Arrestors, Research Triangle Institute, Research Triangle Park, NC, February 1999.
3. Method 319: Determination of Filtration Efficiency for Paint Overspray Arrestors. *Code of Federal Regulations*, Appendix A to 40 CFR Part 63.
4. National Emission Standards for Hazardous Air Pollutants for Aerospace Manufacturing and Rework Facilities. *Code of Federal Regulations*, Title 40, Part 63, Subpart GG (40 CFR 63.741).

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TABLE 6. SUMMARY OF SOLID-PHASE TEST RESULTS

Filtration Efficiency (%) at Indicated Size Range															
OPC Channel Number	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
Min. Diam. (um)	0.45	0.59	0.73	0.80	1.02	1.44	1.86	2.28	2.85	3.13	4.25	5.66	7.07	7.77	9.88
Max. Diam. (um)	0.59	0.73	0.80	1.02	1.44	1.86	2.28	2.85	3.13	4.25	5.66	7.07	7.77	9.88	14.10
Geo. Mean Diam (um)	0.52	0.66	0.77	0.90	1.21	1.64	2.06	2.55	2.98	3.65	4.91	6.33	7.41	8.76	11.81
Farr Riga-Flo 200															
Run #1	10059905	84	90	92	94	97	99	99	100	100	100	100	100	100	100
Run #2	10069901	77	84	88	91	94	97	98	99	99	100	100	100	100	100
Run #3	10069903	81	87	90	93	96	98	99	99	99	100	100	100	100	100
Average		81	87	90	93	96	98	99	99	99	100	100	100	100	100
Interpolated Efficiency Values (%) for Two-Stage Criteria:															
2.60 um (> 10% required):															
5.00 um (> 50% required):															
8.10 um (> 90% required):															
Interpolated Efficiency Values (%) for Three-Stage Criteria:															
0.70 um (> 75% required):															
1.10 um (> 85% required):															
2.50 um (> 95% required):															
HEPA Filter Control Test (applicable to both solid and liquid phase conditions)															
Run #1	10059902	100	100	100	100	100	100	100	100	100	100	100	100	100	100
Reference Filter QA Test															
Current	10059903	0	0	2	3	4	4	8	10	10	14	24	36	48	58
Baseline	07279902	0	0	0	0	1	0	3	5	3	10	20	40	54	65
Difference		0	0	2	2	3	4	5	5	6	4	4	-3	-6	-7
Acceptable (<10%)		yes													
"No Filter" Control Tests															
Penetration For Each Size Range															
Run #1	10059904	1.00	1.00	0.99	1.01	1.01	1.00	1.01	1.01	1.00	1.02	1.00	1.00	0.98	0.99
Run #2	10059906	1.01	1.01	0.99	1.01	1.01	1.00	1.00	1.00	1.02	1.02	1.02	1.01	0.99	0.97
Run #3	10069902	1.00	1.00	1.00	0.99	1.01	1.02	0.98	0.99	1.01	0.99	0.96	0.91	0.89	0.84

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TABLE 7. SUMMARY OF LIQUID- PHASE TEST RESULTS

Filtration Efficiency (%) at Indicated Size Range

OPC Channel Number	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
Min. Diam. (um)	0.28	0.37	0.47	0.52	0.66	0.94	1.22	1.51	1.88	2.07	2.83	3.77	4.71	5.18	6.60
Max. Diam. (um)	0.37	0.47	0.52	0.66	0.94	1.22	1.51	1.88	2.07	2.83	3.77	4.71	5.18	6.60	9.43
Geo. Mean Diam (um)	0.32	0.418	0.49	0.58	0.78	1.07	1.36	1.68	1.97	2.42	3.26	4.21	4.94	5.85	7.89

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Run #1	10089905	72	80	83	86	91	95	97	99	99	99	100	100	100	100
Run #2	10089907	73	80	84	86	91	95	97	99	99	99	100	100	100	100
Run #3	10089909	77	84	87	89	93	96	97	98	98	98	99	99	99	99
Average		74	81	85	87	92	95	97	99	99	99	99	99	99	99

Interpolated Efficiency Values (%) for Two-Stage Criteria:

2.20 um (> 10% required):	99
4.10 um (> 50% required):	99
5.70 um (> 90% required):	99

Interpolated Efficiency Values (%) for Three-Stage Criteria:

0.42 um (> 65% required):	82
1.00 um (> 80% required):	95
2.00 um (> 95% required):	99

"No Filter" Control Tests

Penetration For Each Size Range

Run #1	10089904	0.99	0.99	0.97	1.00	0.99	1.00	1.00	1.00	1.01	1.00	1.01	1.01	1.01	0.99	0.86
Run #2	10089906	1.00	0.99	1.00	1.00	1.00	1.00	1.00	1.00	1.01	1.01	1.01	1.01	1.01	0.99	0.81
Run #3	10089908	0.99	0.99	0.98	0.99	0.99	1.00	0.99	0.99	1.00	1.01	1.00	1.00	0.96	0.94	0.75

Farr Riga-Flo 200

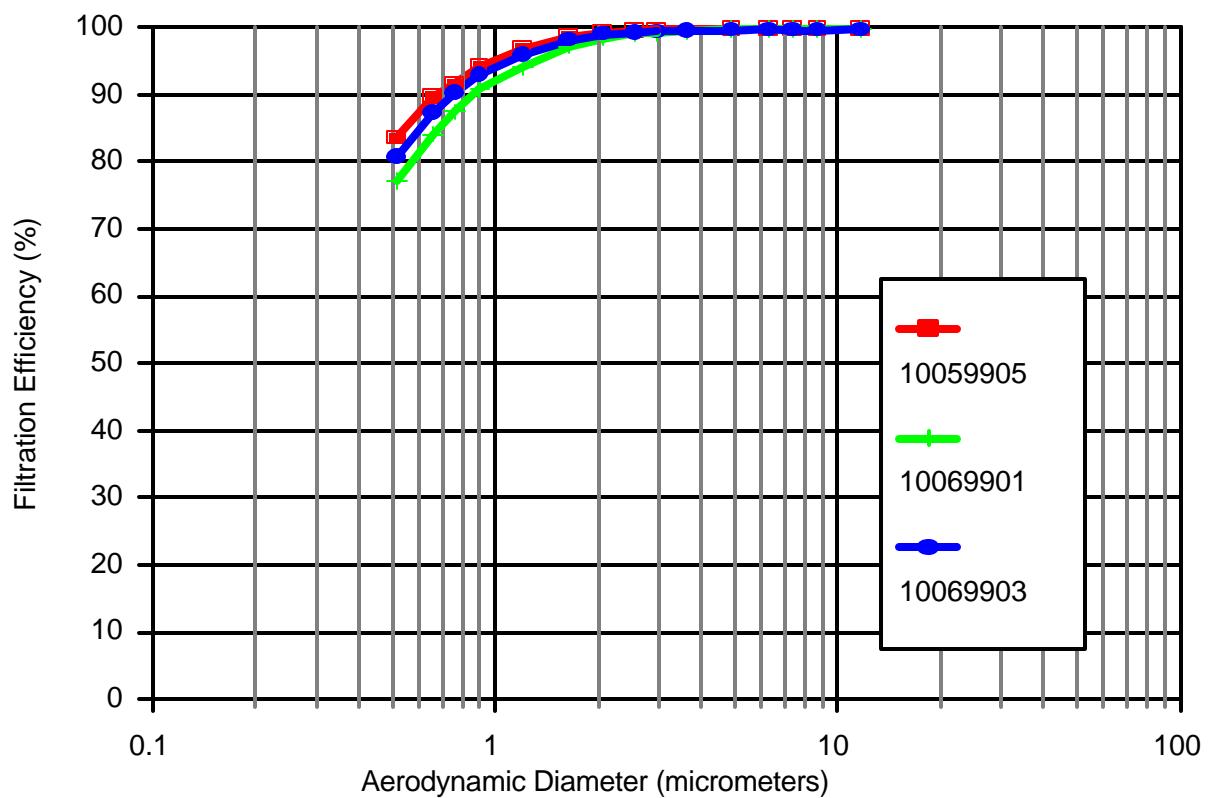


Figure 2. Triplicate solid-phase particle removal efficiency curves for the Farr Riga-Flo 200 paint overspray arrestor.

Farr Riga-Flo 200

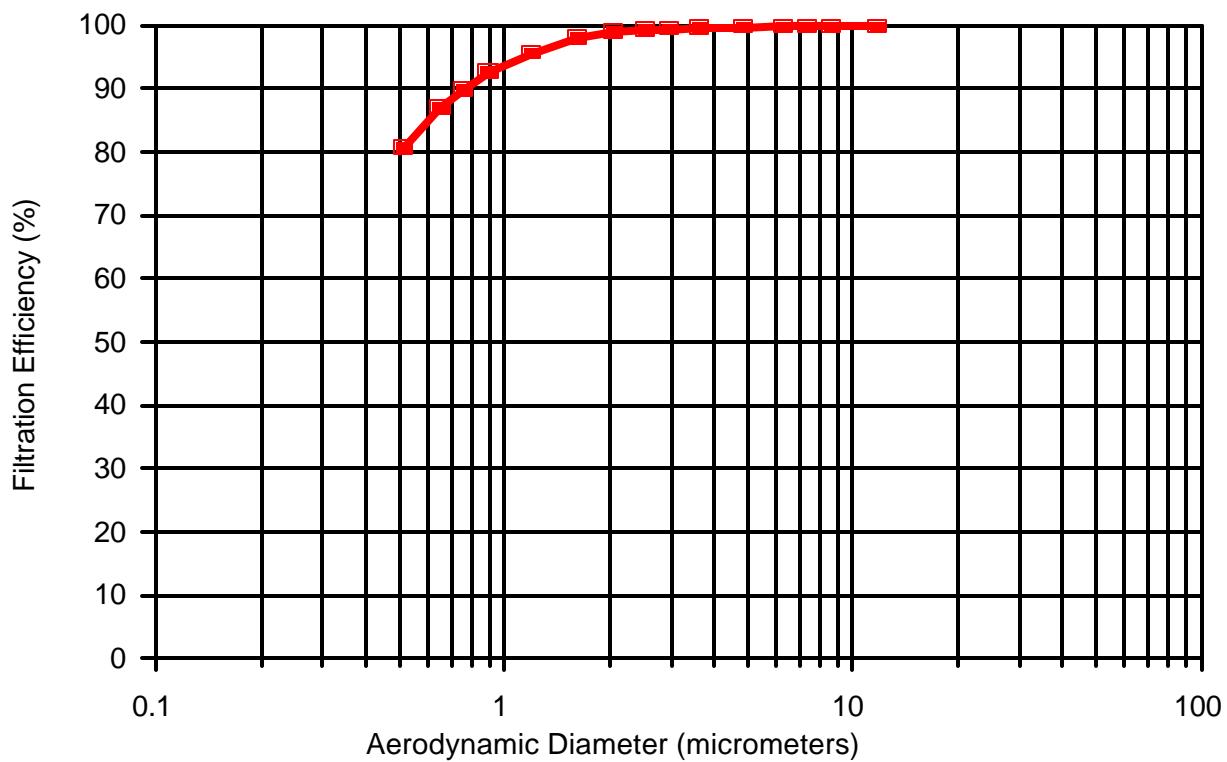


Figure 3. Average of the solid-phase particle removal efficiency curves for the Farr Riga-Flo 200 paint overspray arrestor.

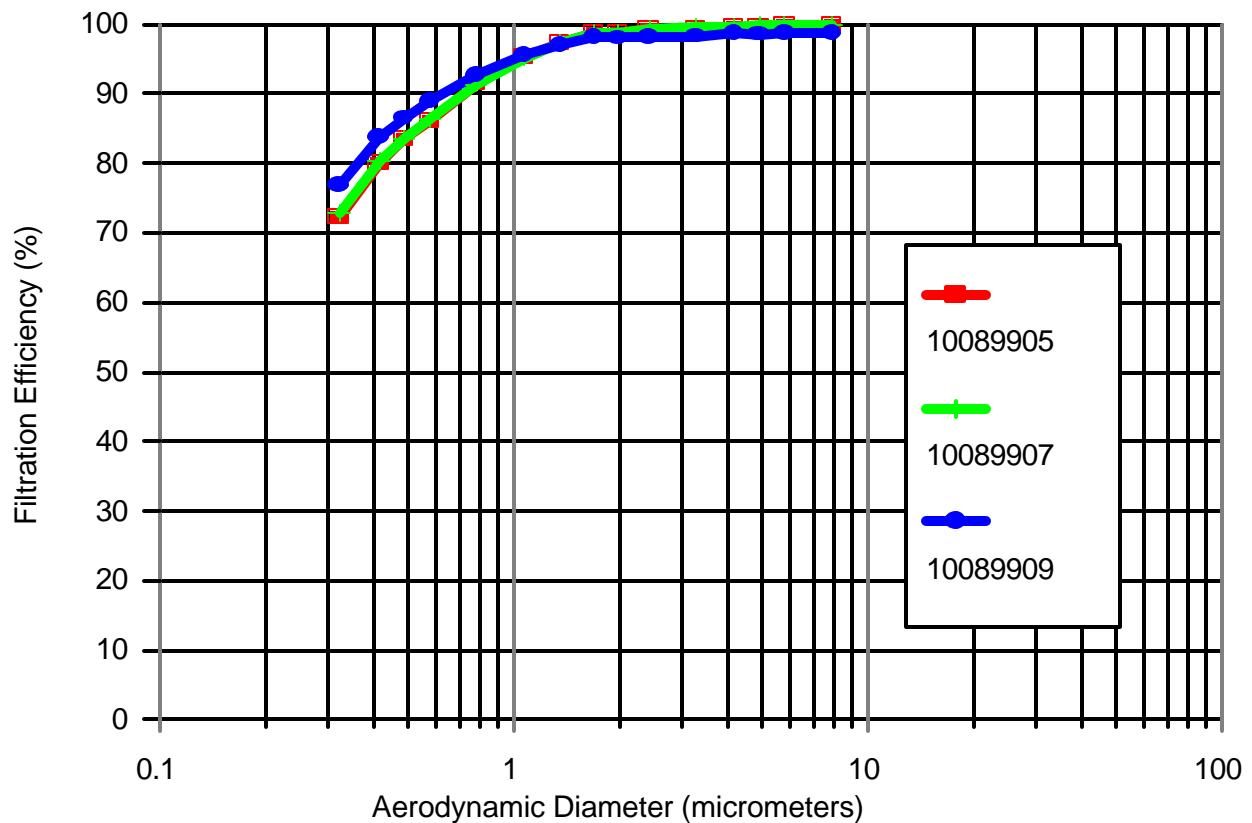


Figure 4. Triplicate liquid-phase particle removal efficiency curves for the Farr Riga-Flo 200 paint overspray arrestor.

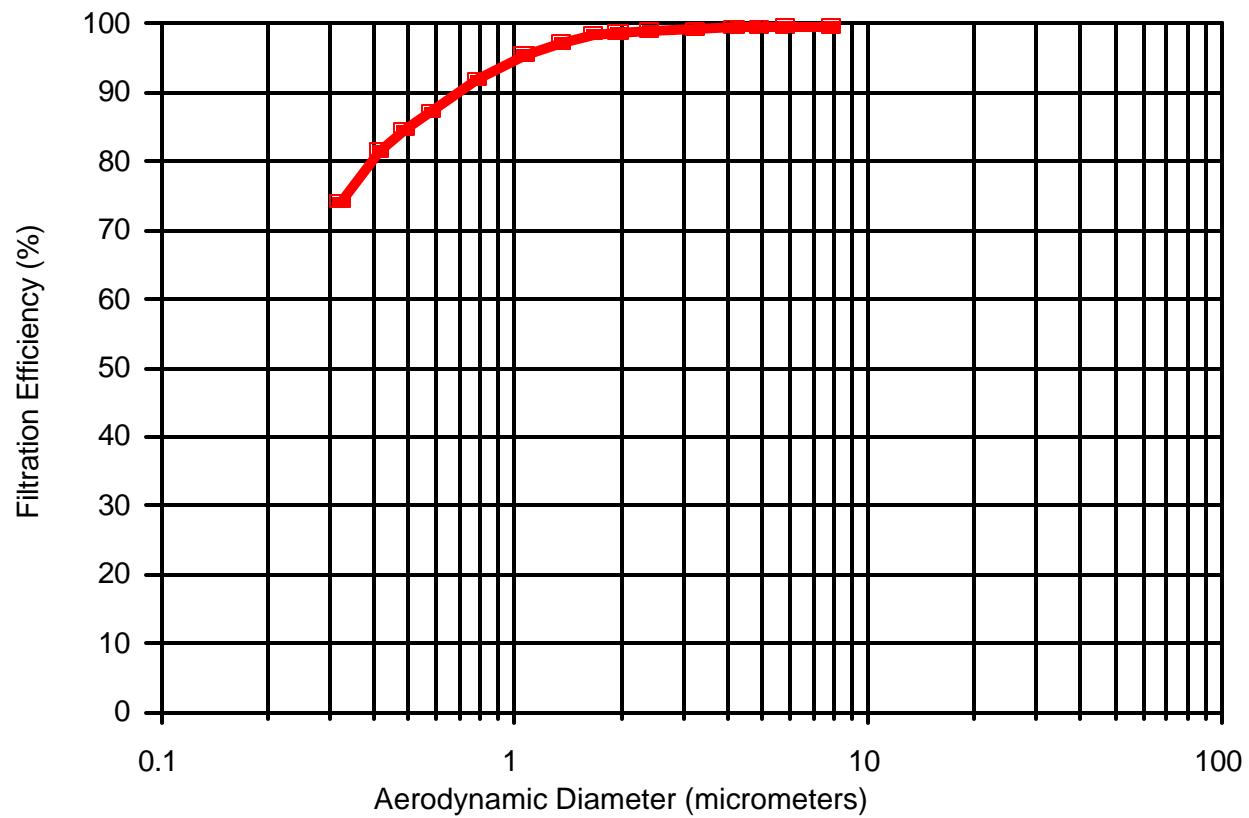


Figure 5. Average of the liquid-phase particle removal efficiency curves for the Farr Riga-Flo 200 paint overspray arrestor.

TABLE 8.
SUMMARY OF PRESSURE DROP MEASUREMENTS

Test No.	Initial Pressure Drop (inch H ₂ O)	Initial Pressure Drop (Pa)
10059905	0.25	62
10069901	0.15	37
10069903	0.24	60
10089905	0.15	37
10089907	0.14	35
10089909	0.19	47

Appendix A

DESCRIPTION OF THE TEST RIG AND METHODOLOGY

TEST DUCT

The tests were conducted in RTI's air cleaner test facility (Figure A-1). The test rig's ducting was primarily of 24 x 24 in. (0.61 x 0.61m) cross section and made of 14-gauge stainless steel. The blower is rated at 15 hp (11 kW) with a flow capacity of 3000 cfm (1.4 m³/s) at 13 in. H₂O (3200 Pa). The inlet and outlet filter banks consist of two 24 x 24 x 2 in. (0.61 x 0.61 x 0.05 m) prefilters and two 24 x 24 x 12 in. (0.61 x 0.61 x 0.30 m) high efficiency particulate air (HEPA) filters rated at 2000 cfm (0.9 m³/s) each. The system operates at positive pressure to minimize infiltration of room air.

To mix the test aerosol with the air stream, an orifice plate and mixing baffle were located immediately downstream of the aerosol injection point and upstream of the test arrestor. An identical orifice plate and mixing baffle were added after the 180° bend. The latter downstream orifice served two purposes. It straightened out the flow after going around the bend, and it mixed any aerosol that penetrated the air cleaning device. Mixing the penetrating aerosol with the air stream is necessary to obtain a representative downstream aerosol measurement.

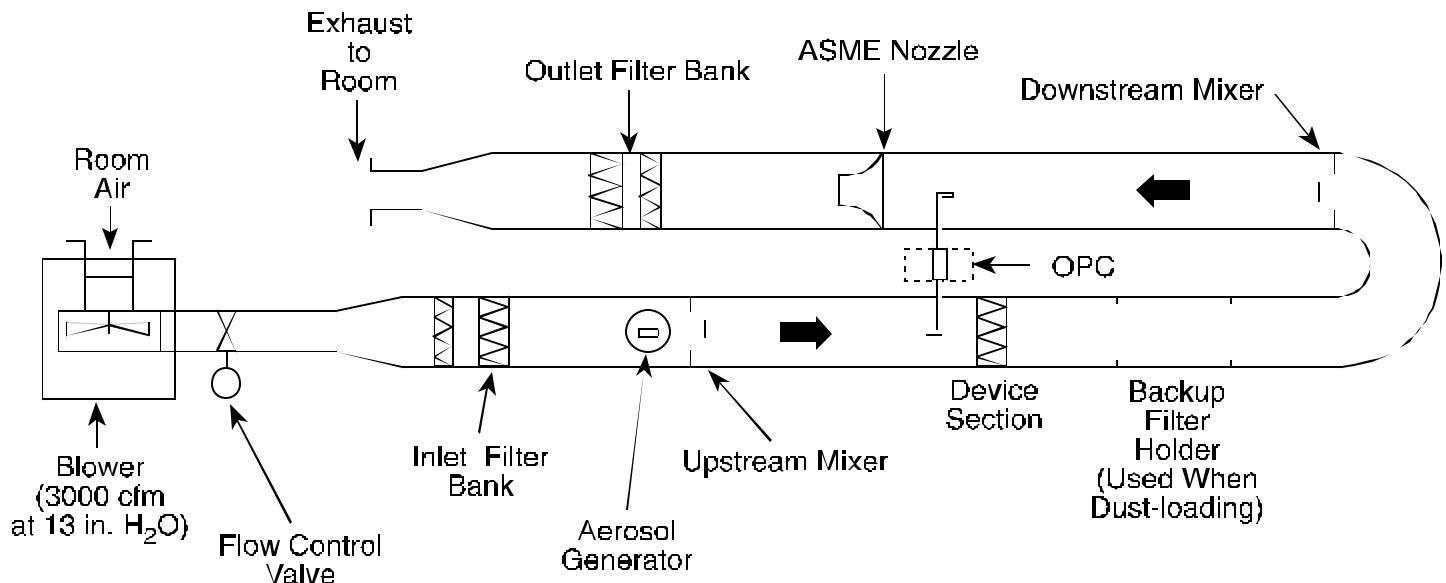
AIRFLOW

Airflow was measured with a 4.00 in. (0.102 m) ID American Society of Mechanical Engineers (ASME) flow nozzle. The nominal velocity through the arrestor was computed by dividing the volumetric flow by the nominal face area of the device. Airflow was manually controlled by a 14 in. (0.36 m) diameter butterfly valve.

OPTICAL PARTICLE COUNTER (OPC)

Aerosol concentrations were measured with a Climet Instruments Model 500 OPC. The OPC has 15 channels covering the range from 0.3 to 10 µm diameter. The OPC uses a laser-light illumination source and has a wide collection angle for the scattered light. The OPC's sampling rate was 0.25 cfm (0.00012 m³/s).

The OPC was equipped to provide a contact closure at the end of each sample and also provides a 15-sec delay in particle counting after each sample. The contact closure was used to control the operation of electromechanical valve actuators in the upstream and downstream sample lines. The 15-sec delay allows time for the new sample to be acquired.



Overview of Test Duct Configuration (Top View)

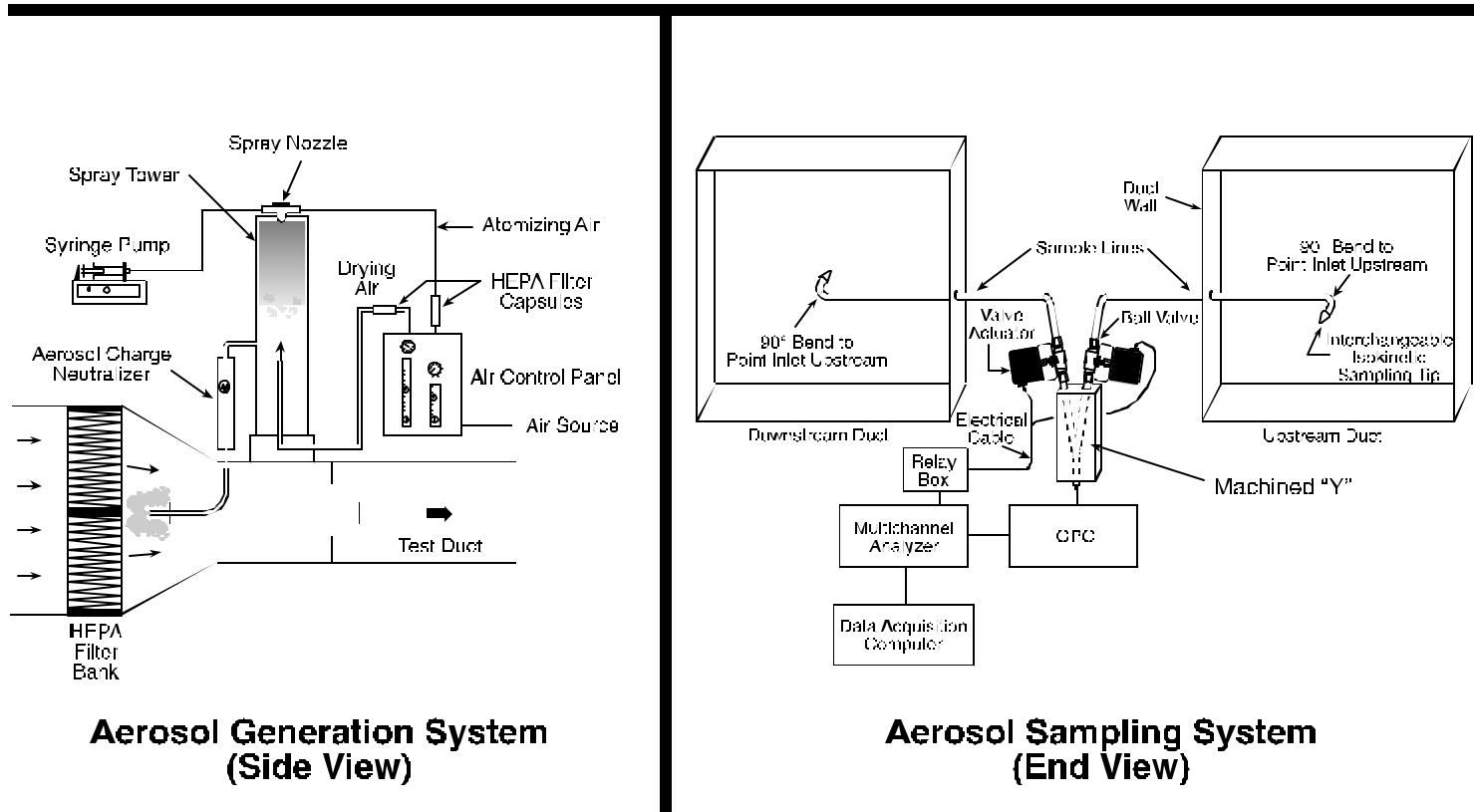


Figure A-1. Schematic illustration of the fractional efficiency test rig.

AEROSOL GENERATION

Two types of challenge aerosols were used: liquid- and solid-phase. The selection of liquid- or solid-phase challenge aerosol particles is important because, for some types of paint arrestors, significantly different filtration efficiencies will be achieved depending upon the phase of the challenge aerosol particles. (This is due to particle "bounce" associated with solid-phase particles.) The liquid-phase challenge aerosol is oleic acid, a non-toxic, low-volatility liquid. The solid-phase aerosol is potassium chloride (KCl) generated from an aqueous solution. KCl was selected as the solid-phase aerosol because of its relatively high water solubility, high deliquescence humidity (85% relative humidity), known crystalline structure (facilitates complete drying), and low toxicity. The KCl solution was prepared by combining 0.66 lb (300 g) of KCl with 0.035 ft³ (1 L) of distilled water. Both oleic acid and KCl are compatible with accurate measurement by the OPC.

The oleic acid or the KCl solution was nebulized using a two-fluid (air and liquid) air atomizing nozzle (Spray Systems 1/4 J siphon spray nozzle) as illustrated in Figure A-1 (aerosol generation system). The nozzle was positioned at the top of a 12 in. (0.30 m) diameter, 51 in. (1.3 m) tall transparent acrylic spray tower. The tower served two purposes. It allowed the salt droplets to dry by providing an approximate 40 sec mean residence time, and it allowed larger-sized particles (of either KCl or oleic acid) to fall out of the aerosol. After generation, the aerosol passed through a TSI Model 3054 aerosol neutralizer (Kr-85 radioactive source) to neutralize any electrostatic charge on the aerosol (electrostatic charging is an unavoidable consequence of most aerosol-generation methods).

The KCl solution or oleic acid was fed to the atomizing nozzle at 1.2 mL/min by means of a pump. Varying the operating air pressure of the generator allows control of the output aerosol concentration.

AEROSOL SAMPLING SYSTEM

The aerosol sampling lines were 0.55 in. (14 mm) ID stainless steel lines and used gradual bends [radius of curvature = 2.25 in. (57 mm)] when needed. These dimensions were chosen to minimize particle losses in the sample lines. A custom-made "Y" fitting connected the upstream and downstream lines to the OPC. The two branches of the "Y" merged gradually to minimize particle loss in the intersection of the "Y" due to centrifugal or impaction forces.

Immediately above the "Y," electrically actuated ball valves were installed in each branch (Parker Model EA Electro-Mechanical Valve Actuator). The opening and closing of the valves were automatically controlled by the OPC's sequential sampling interface board. The valves take approximately 2 sec to complete an opening or closing maneuver.

Isokinetic sampling nozzles of the appropriate entrance diameter were placed on the ends of the sample probes to maintain isokinetic sampling for all the test flow rates.

TEST PROCEDURES

The aerosol penetration of the test device was calculated from the average of 10 upstream and 10 downstream samples taken sequentially (i.e., one upstream, one downstream, one upstream, one downstream, . . . until 10 each were obtained). This sequential sampling scheme was selected to minimize the effect of aerosol generator variability. Each sample was 2 minutes in duration. The sampling also included background upstream and downstream measurements at the beginning and end of each test. The test sequence was as follows:

1. Warm up OPC and install proper sample tips for isokinetic sampling.
2. Install air cleaner test device and bring test duct to desired flow rate.
3. With the aerosol generator off, obtain one measurement each of the upstream and downstream background particle counts.
4. Turn on the aerosol generator and allow it to run for a minimum of 10 minutes to stabilize.
5. After the stabilization period, obtain 10 upstream and 10 downstream particle counts using a repeated upstream-downstream sampling sequence until 10 each are obtained.
6. Turn off the aerosol generator. Wait 10 minutes, then obtain one additional upstream and downstream background measurement.

CONTROL TESTS

In addition to evaluating the test arrestor, 0 and 100% penetration control tests and a reference filter control test were conducted to ensure that reliable measurements are obtained. The 100% penetration test was a relatively stringent test of the adequacy of the overall duct, sampling, measurement, and aerosol generation system. These tests were performed as normal penetration tests except that the paint arrestor was not used. A perfect system would yield a measured penetration of 1 at all particle sizes. Deviations from 1 can occur due to particle losses in the duct, differences in the degree of aerosol uniformity (i.e., mixing) at the upstream and downstream probes, and differences in particle-transport efficiency in the upstream and downstream sampling lines. Results from the 100% penetration tests were used during data analysis to correct penetration measurements obtained during the arrestor tests.

The 0% penetration test was performed by using a HEPA filter rather than a paint arrestor. This test confirmed the adequacy of the instrument response time and sample line lag. The 0% penetration test was performed on a monthly basis.

The reference filter control test consisted of performing a solid-phase efficiency test on the same filter during each ETV test. The reference filter data from each test were compared to the original, baseline reference filter data to determine if there was any substantial change in the test system between the tests.

DATA ANALYSIS

Nomenclature

- P = Penetration corrected for P_{100} value
- D = Downstream particle count
- D_b = Downstream background count
- U = Upstream particle count
- U_b = Upstream background count
- P_{100} = 100% penetration value determined from the control tests
- Overbar: denotes arithmetic mean of quantity

Analysis of each test involves the following quantities:

- ! P_{100} value for each sizing channel from the blank (no-filter) test,
- ! 2 upstream background values,
- ! 2 downstream background values,
- ! 10 upstream values with aerosol generator on, and
- ! 10 downstream values with aerosol generator on.

Using the values associated with each sizing channel, the penetration associated with each particle sizing channel was calculated as:

$$P = \{(\bar{D} - \bar{D}_b) / (\bar{U} - \bar{U}_b)\} / P_{100} .$$

Filtration efficiency was then calculated as:

$$\text{Filtration Efficiency (\%)} = 100(1 - P).$$

DEFINITION OF PARTICLE DIAMETER

Over the 0.3 to 10 μm diameter size range, the "aerodynamic" particle diameter is often of more significance than the physical diameter (as measured by the OPC) relative to aerosol filtration and aerosol deposition within the human respiratory tract. The aerodynamic diameter (D_{Aero}) is related to the physical diameter (D_{Physical}) by:

$$D_{\text{Aero}} = D_{\text{Physical}} \sqrt{\frac{p_{\text{Particle}}}{p_o} \frac{CCF_{\text{Physical}}}{CCF_{\text{Aero}}} \frac{1}{X}}$$

where

p_{Particle} is the density of the particle in g/cm^3 .

p_o is unit density of $1 \text{ g}/\text{cm}^3$.

CCF_{Physical} is the Cunningham Correction Factor at D_{Physical} .

CCF_{Aero} is the Cunningham Correction Factor at D_{Aero} .

X is the dynamic shape factor.

Note: due to the interdependence of D_{aero} and CCF_{Aero} , the equation is solved iteratively.

For oleic acid droplets having a density of $0.89 \text{ g}/\text{cm}^3$ and being spherical ($X = 1$), the aerodynamic diameter will be about 6% smaller than the measured diameter.

KCl has a density of $1.98 \text{ g}/\text{cm}^3$. The KCl particles form from the evaporation of aqueous solution droplets. Because KCl has an inherent cubic crystalline structure, it is expected that the KCl particles will be cubic or relatively compact cubic clusters; however, their actual shape, or range of shapes, is unknown. Because the shape factor is unknown, the shape factor for KCl is assigned a value of 1 and the diameter is termed the "nominal" aerodynamic diameter.

The aerodynamic diameters associated with the 15 OPC sizing channels are tabulated in Table A-1 for oleic acid and KCl. Also listed is the physical diameter size range for each channel based on the manufacturer's calibration curve using monodisperse polystyrene latex (PSL) spheres.

Table A-1. Physical and Aerodynamic Sizing Channels for the Calibration and Test Aerosols

	Particle Diameter Size Range (μm) [*]		
	PSL	OLEIC ACID	KCl
OPC Channel Number	Physical Diameter	Aerodynamic Diameter	Nominal Aerodynamic Diameter
1	0.3 - 0.4	0.28 - 0.37	0.45 - 0.59
2	0.4 - 0.5	0.37 - 0.47	0.59 - 0.73
3	0.5 - 0.55	0.47 - 0.52	0.73 - 0.80
4	0.55 - 0.7	0.52 - 0.66	0.80 - 1.02
5	0.7 - 1.0	0.66 - 0.94	1.02 - 1.44
6	1.0 - 1.3	0.94 - 1.22	1.44 - 1.86
7	1.3 - 1.6	1.22 - 1.51	1.86 - 2.28
8	1.6 - 2	1.51 - 1.88	2.28 - 2.85
9	2 - 2.2	1.88 - 2.07	2.85 - 3.13
10	2.2 - 3	2.07 - 2.83	3.13 - 4.25
11	3 - 4	2.83 - 3.77	4.25 - 5.66
12	4 - 5	3.77 - 4.71	5.66 - 7.07
13	5 - 5.5	4.71 - 5.18	7.07 - 7.77
14	5.5 - 7	5.18 - 6.60	7.77 - 9.88
15	7 - 10	6.60 - 9.43	9.88 - 14.1

*The particle diameter size ranges are defined as greater than the indicated lower limit and less than or equal to the indicated upper limit.

APPENDIX B
Certificates of Calibration

Certificate of Traceability

8500D-II THERMOANEMOMETER

Model No. 8500D-II

Serial No. 3810

Part No. 634493200

Certificate Number: 1046
Customer Number:

Date: 26-Oct-98

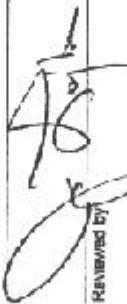
P.O. 00339

Order/RA# 104658

The following standards and equipment were used as references for this calibration.

Tested By	Date Tested	Inst. No.	Cal Due	NIST Test Numbers
LOZADA	10/23/98	747	4/9/00	2693-4C; 25/7602; 25/8500; 25/8569; 25/222; 81/1256692;
		748	4/9/00	81/1256522; 81/1260176;
		922	6/8/00	8365-5654-7-93
		691	11/16/98	81/1257078; 24/770; 25/8605; 31/1265674; 25/3695; USN 22785C; Chem Const; 25/4227;
		637	6/8/00	81/1254736; 81/1251592; 25/1971; 81/1251741; 81/1253632; 81/1252116; 81/1802;
		794	3/1/00	836/25994-7-93
		688	2/21/00	81/1266765; 25/1971; 81/1255004-90; 81/1257773; 25/216;
		399	1/1/98	P-8531A; P-8531B; 381/28; 25/460; 25/5302;
		325	2/4/99	P-8531A; P-8531B; 381/26; 25/4160; 25/9009;
		313	1/1/98	P-8531A; P-8531B; 381/26; 25/4160; 25/5302;
		301	1/21/98	836/257126-96;

Alnor Instrument Company hereby certifies that the above named equipment was found to meet or exceed manufacturer's specification. This certificate is issued to the National Institute of Standards and Technology (NIST) or Bureau of Naval Weapons. The policies and procedures used comply with MIL-STD-4552A. This certificate shall not be reproduced except in full, without the written consent of Alnor.



Reviewed by

26-Oct-98

Date



A T S P C o m p a n y

Alnor Instrument Company
7555 N Under Avenue, Cicero, IL 60707
Tel: 847-677-2600 Fax: 847-677-0539



FILE NO. 040FB:001-19
PAGE 1 OF 1

LETTER OF CERTIFICATION
LAMINAR FLOW ELEMENT

CUSTOMER NAME: RESEARCH TRIANGLE INST

CUSTOMER ORDER NUMBER: 00161

MERIAM ORDER NUMBER: 772900

Meriam Instrument certifies that the completed LFE unit has been calibrated and correlated at several points of flow rate using a Meriam standard, which is controlled per the calibration system requirements of ANSI Z540-1 and traceable to the National Institute of Standards and Technology. The collective uncertainty of the measurement standards has a 1:1 ratio to the acceptable tolerance for the flow rate being calibrated.

The total rms uncertainty of the completed laminar flow unit is +/- .72 % of reading.

CUSTOMER ID NO.: 013716

MODEL NO.: 50MH10-8 SERIAL NO.: 758860-K1

FLOW CURVE/TABLE NO.: 30624

DATE OF CALIBRATION 11-11-1998 BY GEORGE ROBOTKAY

AS RECEIVED CONDITION: / In Tolerance Out of Tolerance NA

AS LEFT CONDITION: / In Tolerance Out of Tolerance NA

CALIBRATION INTERVAL: TO BE DETERMINED BY CUSTOMER BASED ON USAGE OF LFE.

FLOW STANDARD
SERIAL NO.

DATE OF LAST CAL

DATE OF NEXT CAL

WMMC2-6

JAN 1998

JAN 1999

The LFE unit listed hereon has been successfully calibrated in accordance with Meriam Instrument Procedure A-35822.

Michael V. S. Miller

QUALITY ASSURANCE INSPECTOR
MERIAM INSTRUMENT

Jack Weigand

QUALITY ASSURANCE MANAGER
MERIAM INSTRUMENT

CLIMET INSTRUMENTS COMPANY

1320 WEST COLTON AVE., REDLANDS, CA 92374 • PHONE: (909) 793-2788 • FAX: (909) 793-1738

CERTIFICATE OF CALIBRATION

INSTRUMENT CALIBRATED

MODEL: CT-500 aerosol particle counter, S/N 97-1821

CONTROL NUMBER: LA624501

DATE CALIBRATED: 04/03/99 NEXT CALIBRATION: 04/03/00

RECOMMENDED CALIBRATION INTERVAL: 12 months

John W. D.
CALIBRATED BY

John R. Groat
APPROVED BY

TRACEABILITY STATEMENT

This instrument has been calibrated in accordance with ISO 10012-1/ANSI Z540-1 (which replaces MIL-STD-45662A) and relevant portions of Federal Standards 209, ASTM F-50, F322, and F328.

Temperature and Relative Humidity are not controlled during calibration because of the wide operating range of the instrument. The operating limits of this instrument are:

TEMPERATURE: 30°F TO 122°F
HUMIDITY: 0-100%, non-condensing

All test equipment used in the calibration of Climet Instruments' products is calibrated at six-month intervals by an outside calibration service. Calibration certificates for each piece of test equipment are on file at Climet; copies will be supplied if requested.

Calibration traceability to a National Measurement Standard (NMS) is established by using mono-disperse latex spheres as a calibration standard. These spheres are sized by methods traceable, by lot number, to the National Institute of Science and Technology.

APPENDIX C
Fractional Efficiency Data Sheets

Key to notation used in the following tables:

Diam.:	Particle Diameter (μm)
U. Bckgrnd:	The upstream background particle counts measured with the aerosol generator off.
Upstream:	The upstream particle counts measured with the aerosol generator on.
D. Bckgrnd:	The downstream background particle counts measured with the aerosol generator off.
Downstream:	The downstream particle counts measured with the aerosol generator on.
Meas. Penetration:	The penetration computed as:

$$\text{Meas. Penetration} = \frac{(\text{Downstream} \& \text{D. Bckgrnd})}{(\text{Upstream} \& \text{U. Bckgrnd})}$$

P100 Correction Values:	Penetration values measured with no filter in the test section. These values are used to correct subsequent penetration measurements for particle losses within the test duct and sampling system.
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Corrected Penetration:	The measured penetration corrected by the P100 values:
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$$\text{Corrected Penetration} = \frac{\text{Meas. Penetration}}{\text{P100 Correction Values}}$$

Corrected Efficiency (%):	$100 \times (1 - \text{Corrected Penetration})$
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DQO	Data Quality Objective
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Farr Riga-Flo 200

Test No. 10069902										
No Filter Solid-Phase										
Particle Counts per Indicated OPC Channel (1-Minute Samples @ 7.1 L/min)										
OPC Channel Number	1	2	3	4	5	6	7	8	9	10
Min. Diam. (um)	0.45	0.59	0.73	0.80	1.02	1.44	1.86	2.28	2.85	3.13
Max. Diam. (um)	0.59	0.73	0.80	1.02	1.44	1.86	2.28	2.85	3.13	4.25
Geo. Mean Diam (um)	0.52	0.66	0.77	0.90	1.21	1.64	2.06	2.55	2.98	3.65
ENTER DATA BELOW										
U. Bckgrnd	1 Dif	10-06-1999	09:51:35	0.2 CF	1	0	0	0	0	0
U. Bckgrnd	1 Dif	10-06-1999	09:53:41	0.2 CF	0	0	0	0	0	0
Upstream	1 Dif	10-06-1999	09:58:59	0.2 CF	9722	7770	2043	5797	11085	4427
Upstream	1 Dif	10-06-1999	10:01:05	0.2 CF	9496	7585	2088	5843	11013	4554
Upstream	1 Dif	10-06-1999	10:03:11	0.2 CF	9553	7745	1975	5812	11281	4402
Upstream	1 Dif	10-06-1999	10:05:17	0.2 CF	9389	7648	2024	5733	11054	4418
Upstream	1 Dif	10-06-1999	10:07:23	0.2 CF	9916	7731	2008	5797	11172	4538
Upstream	1 Dif	10-06-1999	10:09:29	0.2 CF	9691	7772	2094	5809	11223	4636
Upstream	1 Dif	10-06-1999	10:11:35	0.2 CF	9606	7783	2085	5862	11254	4506
Upstream	1 Dif	10-06-1999	10:13:41	0.2 CF	9780	7855	2131	6005	11603	4656
Upstream	1 Dif	10-06-1999	10:15:47	0.2 CF	9837	7794	2114	5903	11217	4558
Upstream	1 Dif	10-06-1999	10:17:53	0.2 CF	9609	7356	2103	5651	10970	4405
U. Bckgrnd	1 Dif	10-06-1999	10:28:23	0.2 CF	3	0	0	0	0	0
U. Bckgrnd	1 Dif	10-06-1999	10:30:29	0.2 CF	4	1	0	0	0	0
ENTER DATA BELOW										
D. Bckgrnd	2 Dif	10-06-1999	09:52:38	0.2 CF	0	0	0	0	1	0
Downstream	2 Dif	10-06-1999	10:00:02	0.2 CF	9643	7581	2123	5863	10993	4516
Downstream	2 Dif	10-06-1999	10:02:08	0.2 CF	9497	7643	2049	5768	11067	4487
Downstream	2 Dif	10-06-1999	10:04:14	0.2 CF	9662	7716	2014	5772	11208	4449
Downstream	2 Dif	10-06-1999	10:06:20	0.2 CF	9488	7689	2068	5761	10907	4379
Downstream	2 Dif	10-06-1999	10:08:26	0.2 CF	9725	7629	2046	5876	11249	4706
Downstream	2 Dif	10-06-1999	10:10:32	0.2 CF	9638	7762	2129	5806	11202	4484
Downstream	2 Dif	10-06-1999	10:12:38	0.2 CF	9975	7975	2066	5979	11418	4738
Downstream	2 Dif	10-06-1999	10:14:44	0.2 CF	9932	7817	2082	5993	11408	4657
Downstream	2 Dif	10-06-1999	10:16:50	0.2 CF	9555	7603	2019	5715	10930	4521
Downstream	2 Dif	10-06-1999	10:18:56	0.2 CF	9575	7739	2078	5785	10865	4490
D. Bckgrnd	2 Dif	10-06-1999	10:29:26	0.2 CF	11	0	0	0	0	0
Meas. Penetration					1.00	1.00	1.00	1.00	0.99	1.01
P100 correction values					1.00	1.00	1.00	1.00	1.00	1.00
Corrected Penetration					1.00	1.00	1.00	1.00	0.99	1.01
Corrected Efficiency (%)					0	0	0	0	1	-1
Data Acceptance Criteria:										
Total Challenge Counts for Each Channel:	96599	77039	20665	58212	111872	45100	27612	20903	11088	33658
Data Quality Objective:	> 500	> 500	> 500	> 500	> 500	> 500	> 500	> 500	> 500	> 500
Does this meet DQO:	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes
Standard Deviation of Penetration for Each Channel :	0.02	0.02	0.03	0.02	0.02	0.03	0.04	0.04	0.06	0.03
Data Quality Objective:	<0.10	<0.10	<0.10	<0.10	<0.10	<0.10	<0.10	<0.10	<0.30	<0.30
Does this meet DQO:	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes
Maximum observed particle concentration (#/cc):	10.4									
Data Quality Objective: max. allowable conc. (#/cc):	< 14									
Does this meet the DQO:	Yes, (applies to all channels)									

